

Patent Abstracts of Japan

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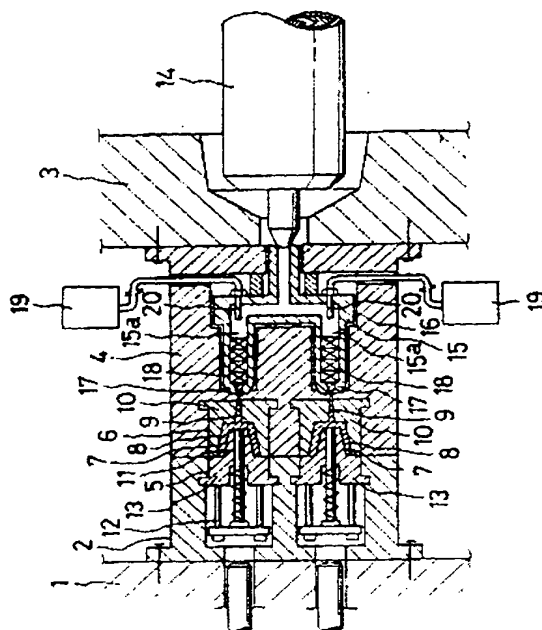
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TITLE : MOLD APPARATUS FOR INJECTION
MOLDING



ABSTRACT : PURPOSE: To inject resin materials having different colors only by slightly performing the lost injection required in the changing of a color and to perform the injection molding of molded products different in coloration at every cavities, by providing a kneading member in a nozzle part in close vicinity to the nozzle orifice thereof and arranging a colorant supply pipe to the rear part of said kneading member.

CONSTITUTION: Colorants are mixed with the molten resin having a natural color injected from an injection apparatus 14 at the rear parts of the nozzle parts of a hot runner block 15, and the colorants and the molten resin are further uniformly kneaded during the passage through kneading members 18, 18 to fill cavities 8, 8. Therefore, molded products 7, 7 colored by the colorants supplied corresponding to the cavities are molded. When the colors of the molded products 7, 7 are desired to be altered, the colorants in colorant feed devices are replaced and molding of several shots is performed to discharge the colorants and colored resins remaining in hot runners 15a, 15a and the nozzle parts. In this case, the colored resins remaining in the nozzle parts are extremely slight and there is also no stagnation amount and, therefore, the changing of a color can be performed within a short time by a small amount of the resin.

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